

Work Order ID 63764

Friday, November 12, 2010 11:59:14 AM



L1+

Page 1

Item ID: D4278-047

Accept



Setup Start



Revision ID: PRELIM

Stop



Item Name: Upper Rib Assembly-Straight



Start Date: 11/15/2010 Start Qty: 2.00



Cust Item ID:



Required Date: 11/16/2010 Req'd Qty: 2.00



Customer:

PRELIMINARY ISSUE

Reference:

Approvals: Process Plan: *MW*

Date: 10-11-12 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

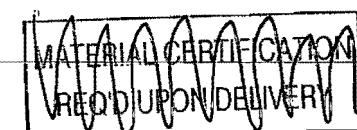
Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr	
D4278	PA1	

100 Weld per dwg A/R S.S. rod Batch: *11585* 0.00*PL 10-11-16*

Large Fab

Memo

0.00

Large Fab

1- Assemble bushing and weld as per dwg
2- Grind weld flush as per dwg

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

NBE
*10-11-16**2 of*

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

*Sawles**4D*

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Page 2

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Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop


**Sequence ID/
Work Center ID**
**Operation
Description**
Set Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: WA

0.00

SAP 10-11-16



Packaging

Memo

0.00

Packaging

STOCK IN BASKET CELL

140

QC21- Final Inspection - Work Order Release

0.00



QC

Quality Control

Memo

0.00

At test location Rev A. AA
10.11.22
POSITIVE RECALL

EFFECTIVE _____ AUTH _____

RELEASED _____ DATE _____

MF
10-11-16

Picklist Print

Page 1

Friday, November 12, 2010 11:59:13 AM

Work Order ID: 63764



Parent Item: D4278-047



Parent Item Name: Upper Rib Assembly-Straight

Start Date: 11/15/2010

Required Date: 11/16/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 10.11.12 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4021-9 Bushing		Manufactured	No.			100	Each	22.0000	2	4			

Location	Loc Qty	Loc Code
WA	22	
56094	2	
60184	4	
60803	16	

D4277-1

Manufactured

No

100

Each

0.0000

1

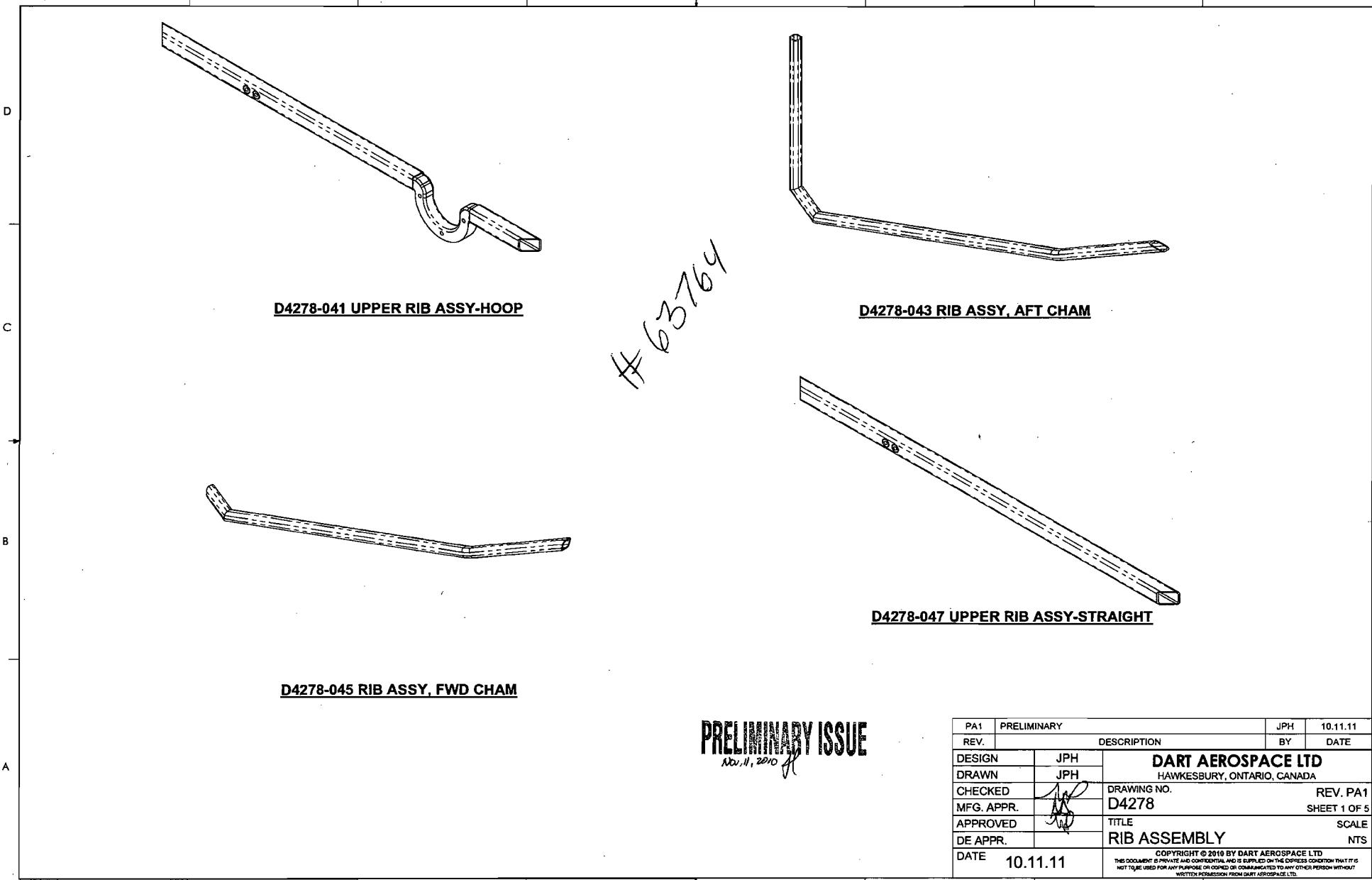
2



Rib

363778 → 2

8 7 6 5 4 3 2 1



PA1	PRELIMINARY	JPH	10.11.11
REV.		DESCRIPTION	BY DATE
DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PA1
MFG. APPR.		D4278	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		RIB ASSEMBLY	NTS
DATE	10.11.11	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

8

7

6

5

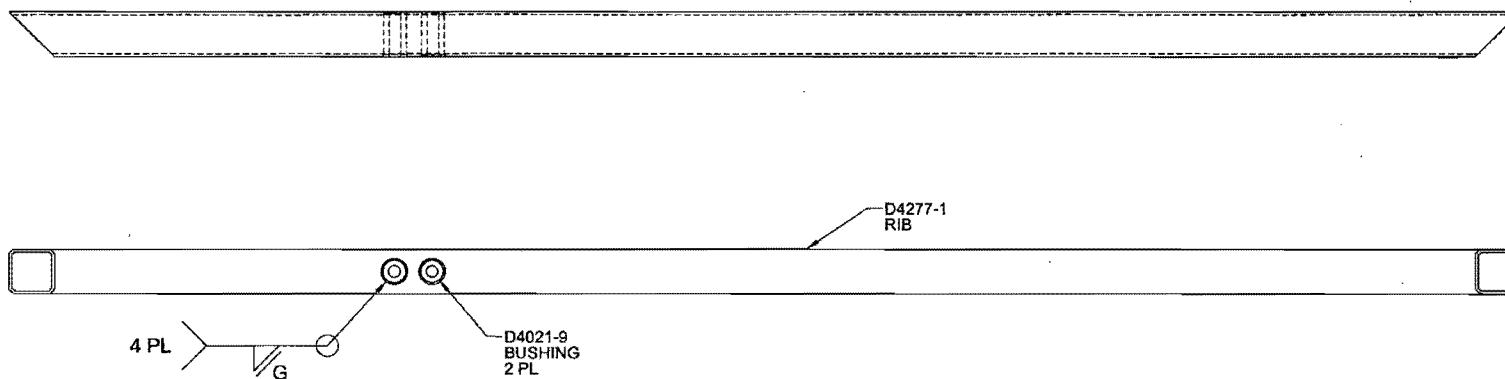
4

3

2

1

ITEM	QTY	PART NUMBER	DESCRIPTION
	-047	D4278-047	UPPER RIB ASSY-STRAIGHT
1	2	D4021-9	BUSHING
2	1	D4277-1	RIB



D4278-047 UPPER RIB ASSY-STRAIGHT

#63769

A

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.92 lbs
- 8) WELD PER DART QSI 004.

PRELIMINARY ISSUE
Nov 11, 2010 JPH

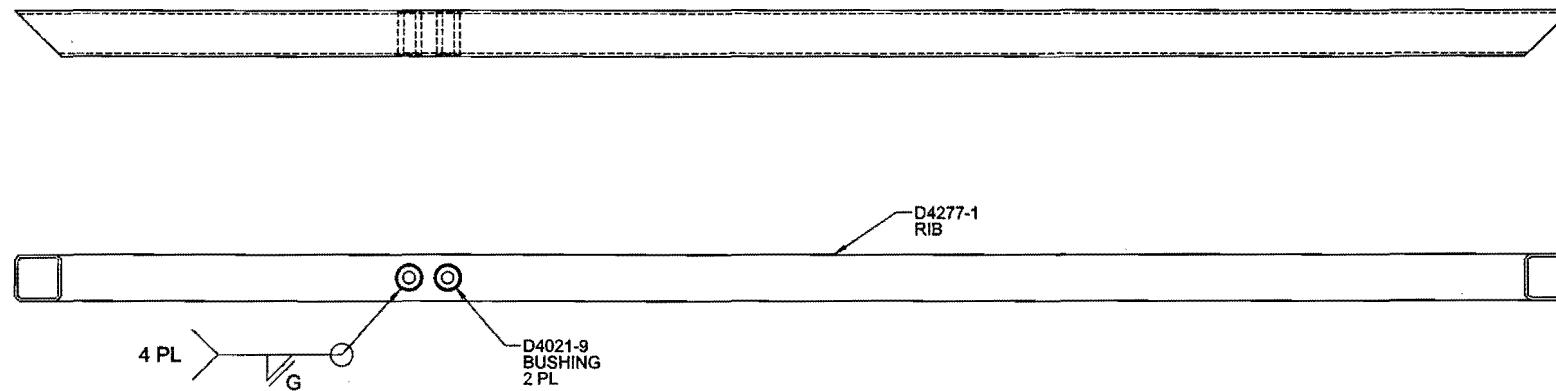
8 7 6 5 4 3 2 1

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	REV. PA1	
MFG. APPR.	<i>[Signature]</i>	SHEET 5 OF 5	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	RIB ASSEMBLY	
DATE	10.11.11	NTS	

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D4278-047 UPPER RIB ASSY-STRAIGHT

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DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4278	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		RIB ASSEMBLY	NTS
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8 7 6 5 4 3 2 1